

Work Order ID 74593

Monday, October 03, 2011 3:58:06 PM

Page 1

Item ID: D3793-3

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 10/3/2011 Start Qty: 12.00

Required Date: 10/5/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date: 11-10-04 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3793

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

304.040

1-Cut as per Dwg D3793

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-10-5

(13)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-10-8

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/11/10/05

(73)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74593

Monday, October 03, 2011 3:58:06 PM



Page 2

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 10/3/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Deburr if necessary
2-Form on Brake as per Dwg D3793 using Jigs

SP 11/10/11

(13)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Swholn

x13

150

0.00



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:15
OVEN TEMPERATURE: 320°F
FINISH TIME: 1:45

13XØ M-L 11/10/11

m118489

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 74593

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Page 3

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 10/3/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

13 ~~PL~~ 11-10-11

170 Identify as per dwg & Stock Location: F-P I

0.00



Packaging

Memo

0.00

Packaging

13x ~~PL~~ 11/10/11

180 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/12 ~~PL~~
CME
11-10-12

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NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 3:58:32 PM

Page 1

Work Order ID: 74593

Parent Item: D3793-3

Parent Item Name: Wearshoe





Start Date: 10/3/2011

Required Date: 10/5/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	170.5795	1.2828	16.20379	17.		
304/316 .040 Sheet											18-10-5		

Location

Loc Qty

Loc Code

MAT020

170.5795

116623

0.2

117550

8.363

117933

45.3442

118400

33.6723

118964

83

118964

(13)

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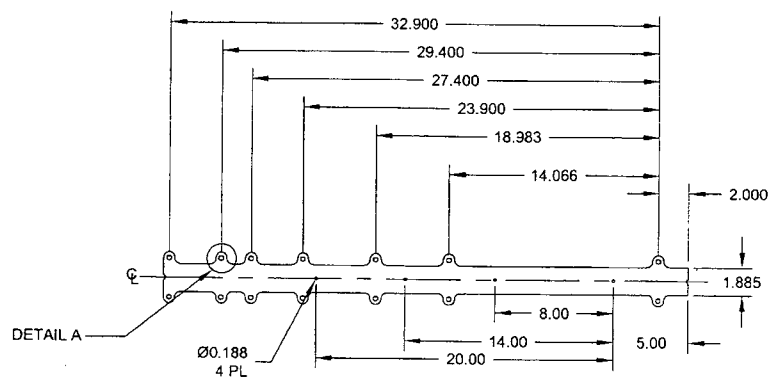
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

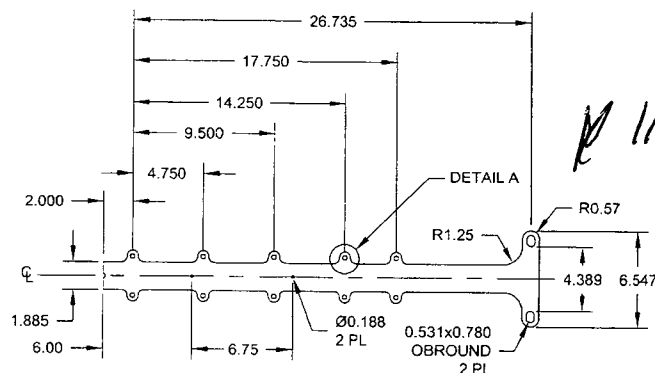
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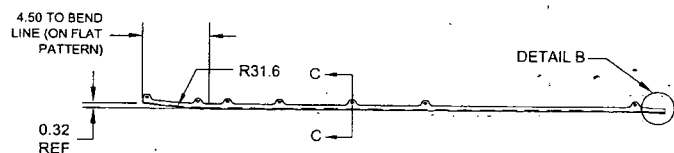
8 7 6 5 4 3 2 1



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08-05-23/18

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	NEW ISSUE	PH	08.05.14
DESIGN	DESCRIPTION	BY	DATE
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	08.05.14		
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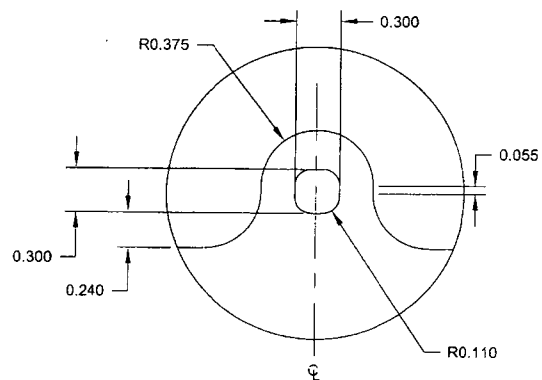
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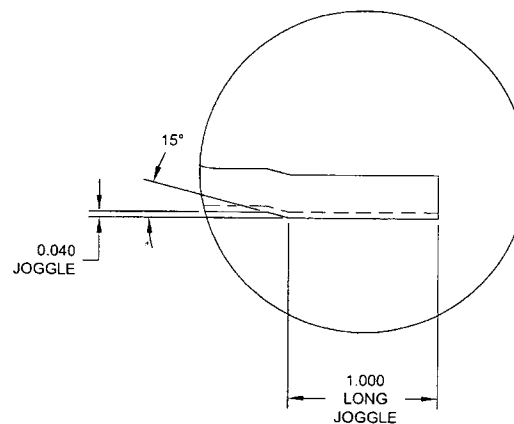
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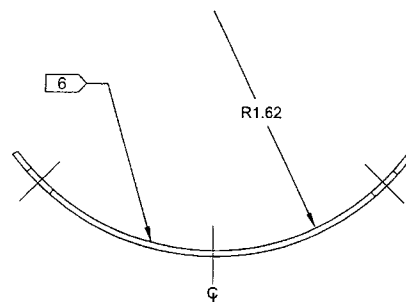
1



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

74593

RELEASED

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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2

1

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